



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBE-350DAMPER Job Sheet 170561



Part No: RBE-350DAMPER

Job Qty: 6 ea

Part Name: Damper Spanner Wrench



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/17/18

Job Tracking No:

Due Date: 2/27/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBE-350DAMPER REV:1 IPP REV:A 18.01.16 NEW ISSUE RQ VERIFIED BY DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		2/27/18	0.00	0.00	Start Up Large Fab-3		EL
95	Large Fab	6 pcs		2/27/18	0.00	1.50	Large Fab 3		EL
100	QC	6 pcs		2/27/18	0.00	0.00	QC5		PD 18-3-7
110	QC	6 pcs		2/27/18	0.00	0.00	QC9		PD 18-3-7
115	HandFinish	6 pcs		2/27/18	0.00	0.00	HandFinish7		BEB 18-03-07
120	Outsource	6 pcs		2/27/18	0.00	0.00	Outsource12		AT 18/03/14
125	Packaging	6 pcs		2/27/18	0.00	0.00	Packaging2		AT 18/03/14
126	QC	6 pcs		2/27/18	0.00	0.00	QC6		38 DAS 9-89
130	Packaging	6 pcs		2/27/18	0.00	0.00	Packaging3-2		GA 21 MAR 2 1 2018
500	QC21-FG	6 Ea		2/27/18	0.00	0.00	QC21		GA 14/13 DAS 9-89

Part Op 95 - WELD AS PER DWG

Descriptions: 120 - Issue P/O to Groupe Altech; PO 39245 - Black oxide finish, MIL-C-13924C Class 1 - Certificate of Conformity is required
130 - Identify and Stock

MAR 08 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBE-350DAMPER-03	Adjustable spanner	6 Ea (1 ea)	90-Start up Operation	
RBE-350DAMPER-05	Pin	12 Ea (2 ea)	90-Start up Operation	

Part Specifications

Specifications could not be found.

Plex 1/17/18 11:20 AM Dart.lajeunesse.marie

21L 3-24



Dart Aerospace Ltd.
1270 Aberdeen Street
Howkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S048091



Part: RBE-350DAMPER

Job No: 170561

Serial No/Batch: S048091

Revision: 1

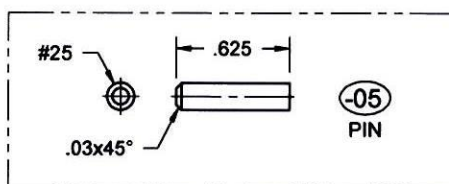
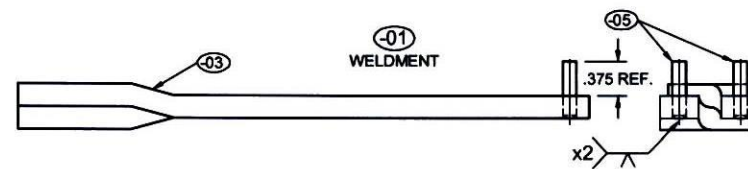
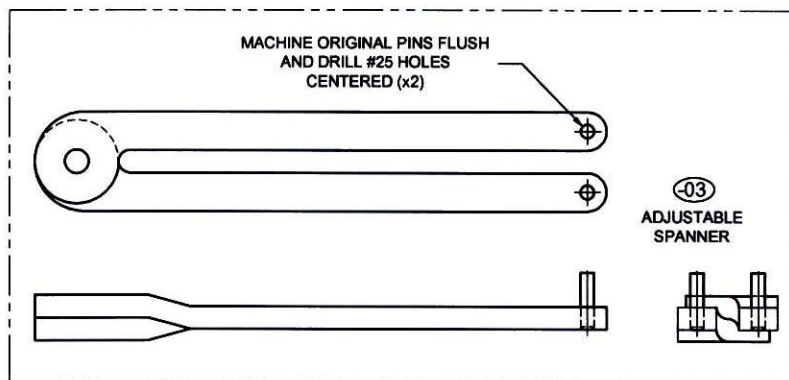
Inspector:

Date: 03/06/18

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
1	DESIGNED PER HELI PRODUCTS TOOLS.	9/9/09	WP DW

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 170561 MWS
18-01-17



FUNCTION: USED TO REMOVE DAMPER CAP

ASSY QTY	ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS
	1	MACH	-01	1	WELDMENT		
	1	MACH	-03		ADJUSTABLE SPANNER	FORGED STEEL	MCMaster-CARR #5481A1
	2	MACH	-05		PIN	DRILL ROD	#25 MCMaster-CARR #3009A237
	1	ASSY	-01				

RED BARN MACHINE	
TITLE DAMPER SPANNER WRENCH	
DWG NO. RBE-350DAMPER	REV 1
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1	
FRACTIONS ± 1/32 ANGLES ± .5°	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 9-9-09
SHEET 1 of 1	

DRAWN BY: PERRITT
APPROVED <i>D. Mott</i>
HEAT TREAT FINISH SPEC BLACK OXIDE
USED ON MODEL EUROCOPTER AS350/355

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO039245

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO039245
PO Date: 3/8/18
Due Date: 3/14/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

E-MAILED

MAR 12 2018

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments: part are RUSH please advise delivery

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	172459	RBE350A94-3700-A-03	Top -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	3/14/18	9 pcs	0 pcs	9 pcs	\$4.4444/pcs	\$40.00
2	170561	RBE-350DAMPER	Damper Spanner Wrench -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	3/14/18	6 pcs	0 pcs	6 pcs	\$4.4444/pcs	\$26.67
3	171155	RBE350A94-2708-01-15	Rod Assembly -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13964, CLASS 1; MIL-C-16173 GRADE 4 -Certificate of Conformity is required	Firmed	3/14/18	6 pcs	0 pcs	6 pcs	\$4.4444/pcs	\$26.67
4	171363	RB AN8514-1-3	Bolt -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	3/14/18	6 pcs	0 pcs	6 pcs	\$4.4444/pcs	\$26.67
5	R173336	PC250-1110	Bolt -Issue P/O to Groupe Altech: P/O _____ -Cadmium plating, QQ-P16F TYPE II, CLASS II -Color: Yellow - Certificate of Conformity is	Firmed	3/14/18	2 pcs	0 pcs	2 pcs	\$87.50/pcs	\$175.00



2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Certificat de Conformité / Certificate of Compliance



Bon de Livraison / Packing Slip

007463- 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
16-Mar-2018		Celine Schreindorfer		PO039245				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir / Back Order
1	RBE350A94-3700-A-03 Rev.	RBE350A94-3700-A-03 BLACK OXIDE FINISH, MIL-C-13924C, CLASS 1	BLACK-OXIDE CH	16	16	0	0	0
2	RBE350DAMPER Rev.	RBE350DAMPER 01 -BLACK OXIDE FINISH MIL-C-13924C, CLASS 1	BLACK-OXIDE CH	6	6	0	0	0
3	RBE350A94-2708-01-15 Rev.	RBE350A94-2708-01-15 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13964C, CLASS 1 MIL-C-16173 GRADE 4	OXIDE-BLACK CH	6	6	0	0	0
4	RB AN8514-1-3 Rev.	RB AN8514-1-3 01 -OXIDE BLACK [OXIDE BLACK] FINISH MIL-C-13924C CLASS 1	OXIDE-BLACK CH	6	6	0	0	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.